

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009069**Date Inspected:** 05-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Hong Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA inspector randomly observed the following work in progress in the trial assembly area:

5AE - ABF performing MT and grinding at the deck panel diaphragm to upper floor beam welds in the corner assembly areas, north and south.

3BW, east of panel point 23, ZPMC workers installing wire clips onto 10mm wire on the traveler rails. This QA inspector observed the workers installing the wire clips backwards, in a manner not recommended by the wire manufacturer.

Bay 11

This QA inspector randomly observed the following work in progress in Bay 11:

FCAW welding of weld joints ESTL3-4B/K-79, 80 located on east tower, lift 3, skins B/C at diaphragm 85.25.

Welder was identified as 070212. ZPMC QC was identified as CWI Li Hong Fei (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-Tc-P4-F for weld joint 79 and

WPS-B-T-2331-Tc-P4-F for weld joint 80.

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FCAW welding of weld joints ESTL3-4B/K-79, 80 located on east tower, lift 3, skins B/C at diaphragm 92.5. Welder was identified as 066471. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-Tc-P4-F for weld joint 79 and WPS-B-T-2331-Tc-P4-F for weld joint 80.

FCAW welding of weld joints ESTL3-4B/K-79, 80 located on east tower, lift 3, skins B/C at diaphragm 95.5. Welder was identified as 068206. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-Tc-P4-F for weld joint 79 and WPS-B-T-2331-Tc-P4-F for weld joint 80.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

This QA inspector informed day shift Caltrans QA personnel of the wire clips being installed backwards as noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
